

Work Order ID 159021

Tuesday, April 04, 2017 4:29:34 PM

159021

Page 1

Item ID: D044-715-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R44 Cargo Mirror
 Start Date: 4/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/18/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference: SCHEDULED

Approvals: Process Plan: **DAS 21 9-89** Date: **APR 05 2017** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3243	Rev A								
IIN-D044-715	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-715-011								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

APR 06 2017

DAS 6 9-89

DAS 28 9-89

APR 10 2017

DAS 6 9-89

APR 07 2017

DAS 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.03 0.00							
						DAS 28 9-89		APR 08 2017	
130 *130* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D044-715-011 LOCATION: FG011	0.00 0.00							
						DAS 28 9-89		APR 08 2017	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.10 0.10							
						DAS 21 9-89		APR 10 2017	
						DAS 21 9-89		APR 10 2017	

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 159021

159021

Parent Item: D044-715-011

D044-715-011

Parent Item Name: R44 Cargo Mirror

Start Date: 4/10/2017

Required Date: 4/18/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A04.02.18New issueKJ/JLM
IPP Rev:B 06-04-28 Manufactured on Water Jet JLM
IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D
11.05.04 remove FE-032-EF DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3243-041 Bracket		Manufactured	No			110	Each	3.0000	1 **	1	DAS 6 9-89	APR 07 2017	DAS 27 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST486			3						
				150498			3						
D1048 Clamp		Manufactured	No			110	Each	17.0000	2 **	2	DAS 6 9-89	APR 07 2017	DAS 27 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			17						
				148270			17						
D1049 Saddle		Manufactured	No			110	Each	9.0000	2 **	2	DAS 6 9-89	APR 07 2017	DAS 27 9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			9						
				148238			4						
				152191			5						

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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D044-715-011

Parent Item Name: R44 Cargo Mirror

Start Date: 4/10/2017

Required Date: 4/18/2017

Start Qty: 1.00

Required Qty: 1.00

D2010-104 Manufactured No

110 Each

7.0000

1 1

D2010-104

ARM

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST351

7

152158

3

156194

4

DAS
6
9-89

APR 07 2017

DAS
27
9-89

D2011-101 Manufactured No

110 Each

17.0000

1 1

D2011-101

Mirror 6"

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

1

106348

1

ST384

16

154144

4

154437

12

DAS
6
9-89

APR 07 2017

DAS
27
9-89

AN3-4A Purchased No

110 Each

222.0000

4 4

AN3-4A

Bolt

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST350

222

m136579

222

DAS
6
89

APR 07 2017

DAS
27
9-89

AN526C1032R10 Purchased No

110 Each

63.0000

4 4

AN526C1032R10

Screw

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST326

63

m135133

63

DAS
6
9-89

APR 07 2017

DAS
27
9-89

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Shop Packet Print

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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D044-715-011

Parent Item Name: R44 Cargo Mirror

Start Date: 4/10/2017

Required Date: 4/18/2017

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130 AELS4-1032-130 Purchased

No

110

Each

3,814.000

4

4

AI S4-1032-130

Rivnut

**

DAS
28
9-89

Location

Loc Qty

Loc Code

CCK007

3632

M136579

3632

FG

50

FG

M135442

50

FP001

132

M133077

72

M135442

60

NAS1149D0332J

Purchased

No

110

Each

1,676.000

4

4

NAS1149D0332.J

Washer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

FP

22

m136015

22

GA

522

m136643

522

ST260a

1000

m137075

1000

ST264

132

m136015

132

DAS
27
9-89
APR 11 2017

DAS
27
9-89
APR 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

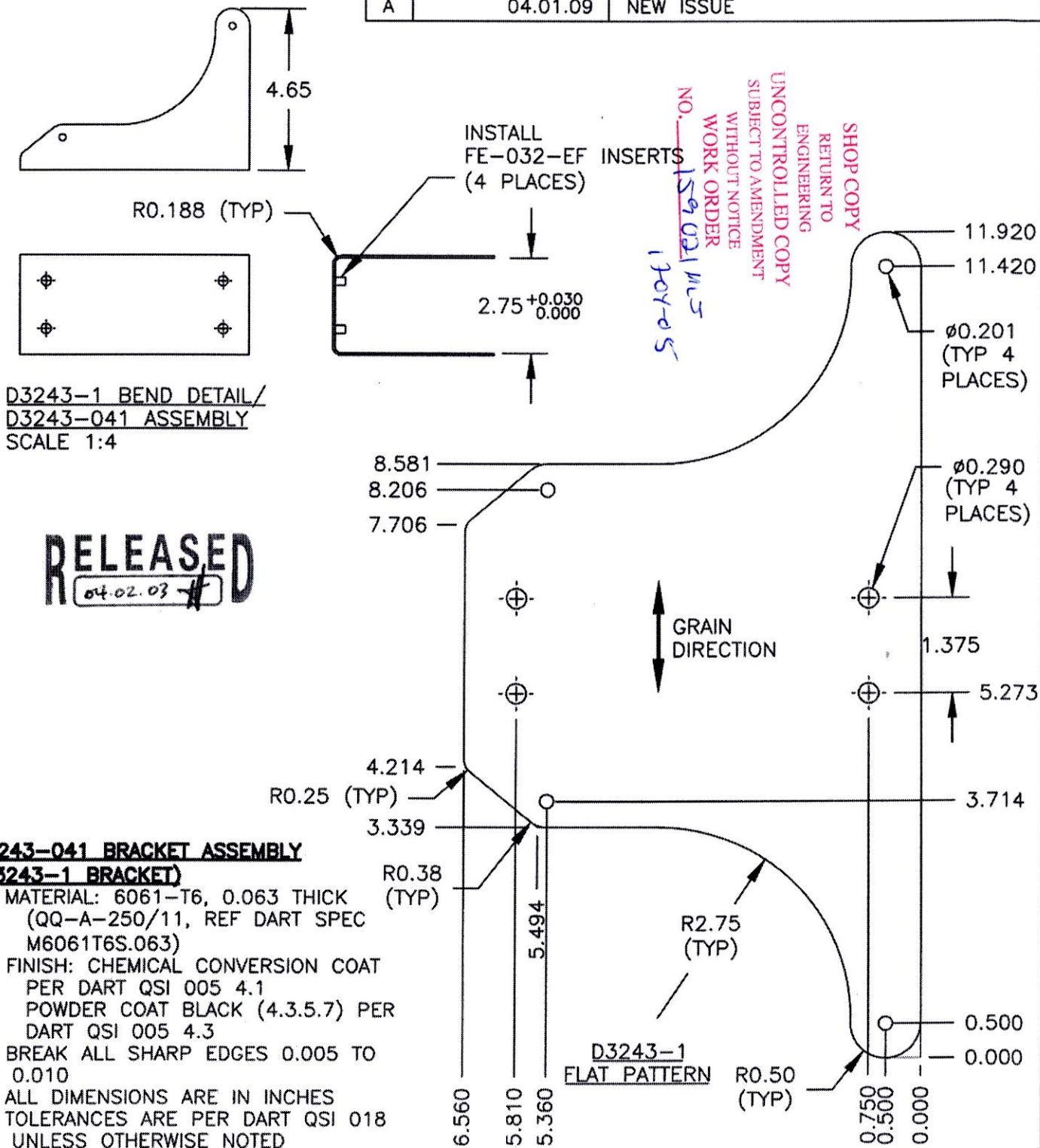
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Misidentified ☐	Past Due ☐																																																																



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



RELEASED
04-02-03

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness **ICA-D044-715**.

3. INSTALLATION INSTRUCTIONS

To install the Dart Cargo Mirror Installation on the R44 skidtube:

1. Locate the D3243-041 Bracket with approximately 0.38" (10mm) space between the top of the skidtube and the bracket, as shown in Figure 2. Transfer drill the 4 holes from the bracket to the centerline of skidtube and enlarge to 10/64" (Ø0.297"). Deburr holes and wet install ALS7-1032-130 inserts using MIL-P-85582 or MIL-P-23377 primer.
2. Install the D3243-041 Bracket on the skidtube using the AN3 hardware. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing as per Figure 2.
3. Install remaining hardware per Figure 2 as required. Adjust the angle of the D2010-104 Arm and tighten the AN526C1032R10 screws to secure arm.
4. To adjust the mirror: loosen (DO NOT REMOVE) the three adjustment screws shown in Figure 2, reposition the mirror, then tighten the screws.

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-715-011 Cargo Mirror Installation	1.3 lb 0.59 kg	41.7 in 1.06 m	54.2 lb-kG 0.63 m-kG	32.0 in 0.81 m	41.6 in-lb 0.48 m-kG

5. PARTS LIST

Qty	Part Number	Description
X	D044-715-011	CARGO MIRROR INSTALLATION
2	D1048	Clamp
2	D1049	Saddle
1	D2010-104	Arm
1	D2011-101	Mirror
1	*D3014-1	Locknut
1	D3243-041	Bracket
4	ALS7-1032-130	Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130)
4	AN3-4A	Bolt
4	AN526C1032R10	Screw (or AN526-1032R10)
4	AN960JD10L	Washers
1	*AN960JD416L	Washer

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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IIN-D044-715	Rev A								
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100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-715-011	CHG003							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

eB DAS 21 8-89 APR 06 2017